

Work Order ID 85943

85943

Page 1

June-19-12 8:00:13 AM

Item ID: D2056

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bell Crank

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2056	Rev B2								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 2.80" long								
110		0.00							
110	HAAS CNC VERTICAL-MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2056								
	Tumble								
	Deburr								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

BT 12-06-24

B.A 12/06/26

BT 12-06-25

BT 12-06-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
3200F
9:20

20 20 12-6-27

20X 12/07/03

ML 21279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 20.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20

20

20/16 12/07/03

170

Identify as per dwg & Stock Location: GA

0.00

170

Packaging

Memo

0.00

Packaging

20x

SP 12-7-3.

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/4

ME 12-07-03

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NOTE: Date & initial all entries

Picklist Print

June-19-12 8:00:18 AM

Page 1

Work Order ID: 85943

85943

Parent Item: D2056

D2056

Parent Item Name: Bell Crank

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP E02.04.04Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	12.1400	0.2375	4.6666			

M6061T6B1 250X01 250

6061-T6 Bar 1.25 x 1.25

**

RT 12-06-24

Location

Loc Qty

Loc Code

MAT004

12.14

119318

12.14

4.6666

Dart Aerospace Ltd

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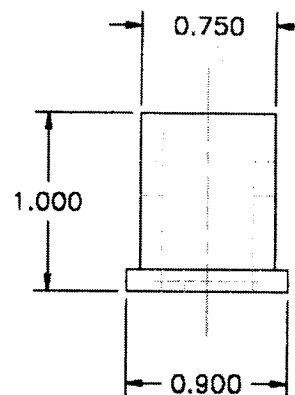
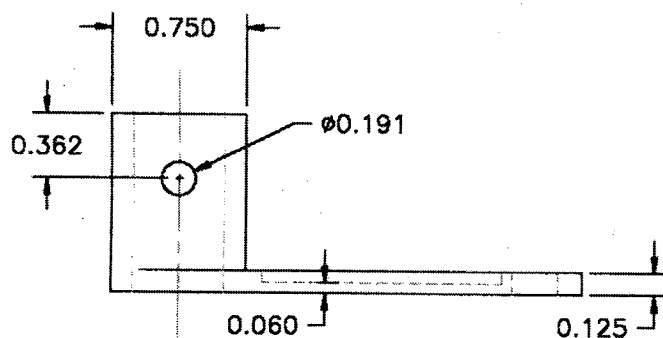
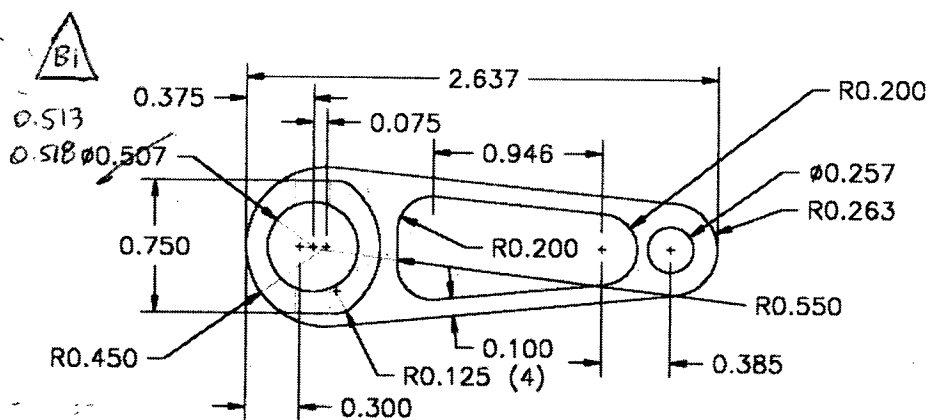
NOTE: Date & initial all entries

RELEASED
99.09.28 JAE

DART



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTIFYING
WORK CENTER
NO. 85943 MLJ
12/06/19



△ B1 ACID ETCH & ALUMINE PER
DART QSE QUS 4.1
POWDER COAT BLACK SATIN
(4.3.5.7) PER DART
QSE QUS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
B1	JAE	D2056
DATE	TITLE	SHEET 1 OF 1
92-03-13	BELL CRANK	1:1
REV. B	SCALE	REVISIONS
B2	1:1	ADD NOTE ON TOLERANCES

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DART AEROSPACE LTD		Work Order:	85943
Description: Bell Crank		Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.750	✓		vern	BT-4
0.900	+/-0.010	.901	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.125	+/-0.010	.125	✓		"	
0.060	+/-0.010	.059	✓		mic 1"	BT-1
Ø0.191	+0.005/-0.001	.191	✓		vern	BT-4
0.362	+/-0.010	.360	✓		vern	BT-4
0.750	+/-0.010	.751	✓		"	
0.385	+/-0.010	.3885	✓		"	
Ø0.257	+0.006/-0.001	.257	✓		✓	
0.100	+/-0.010	.101	✓		"	
0.300	+/-0.010	.300	✓		"	
0.946	+/-0.010	.938	✓		"	
0.075	+/-0.010	.075	✓		"	
2.637	+/-0.010	2.638	✓		"	
0.375	+/-0.010	.375	✓		"	
Ø0.513-0.518	0.513 - 0.518	.515	✓		"	
R0.450	+/-0.010	.450	✓		"	
R0.125	+/-0.010	.125	✓		"	
R0.200	+/-0.010	.200	✓		"	
R0.550	+/-0.010	.550	✓		"	
R0.263	+/-0.010	.261	✓		"	

Measured by:	BT	Audited by:	SL	Prototype Approval:	N/A
Date:	12-06-25	Date:	12-06-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	BT

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